

Date: Wednesday, 9/6/2006 3:43:59 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET  
 Job Number : 28435  
 Estimate Number : 10364  
 P.O. Number : N/A Part Number : D3046041  
 This Issue : 9/6/2006 S.O. No. : N/A Drawing Number : D3046 REV. A UNDER REVIEW  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A  
 Previous Run : 27466 Material : N/A  
 Due Date : 9/13/2006 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: A 010827 New issue SM/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30461 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	B 28440

2.0 D30463 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

LUG BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3046-3 ( Bell P/N: 206-052-106-1)	Lug Bracket	N/A B 28450 B 28451

Return Authorization # SR + S15

Bell original batch#

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046
- 2- Counter sink inside holes of D3046-1 as per Dwg D3046
- 3- Deburr

MF. 06/09/11  
 SMO 06/09/11

4.0 MS20426AD57 Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 60.0000 Each(s)

Rivet

Qty	Part Number	Description	Batch
10	MS20426AD5-7	Rivet	A 3876

SB 06/09/11 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/6/2006 3:43:59 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28435

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

SB

06/09/12

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/09/12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FL

06/09/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/09/12

9

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06/09/12

9

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/09/12

9

Job Completion

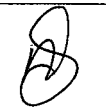
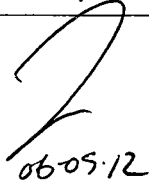

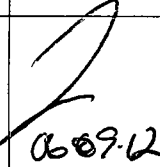
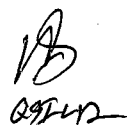
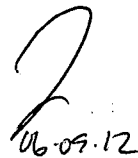

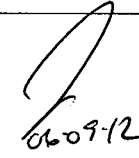


06/09/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 06/09/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

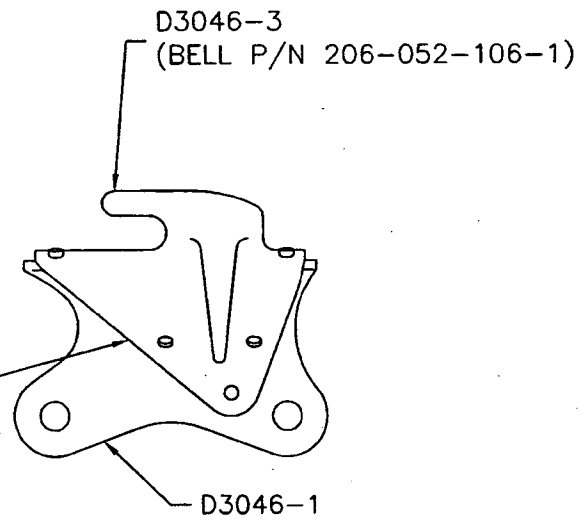
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-09-12	5.0	Upon fitting & forming D3046-3 for installation onto D3046-1 lug. The -3 broke on the end.	 06-09-12	Part is scrap. Destroy.	06-09-12	 06-09-12	 06-09-12	 06-09-12
06-09-12	5.0	Lug ass'y doesn't fit onto tube sample, due to the contour fit of the D3046-3 bell part, and the thickness build-up on the D3046-1	 06-09-12	<del>Here</del> Engineering re-doing design, so part properly mates with skirt tube.	06-09-12	 06-09-12	 06-09-12	 06-09-12

NOTE: Date & initial all entries

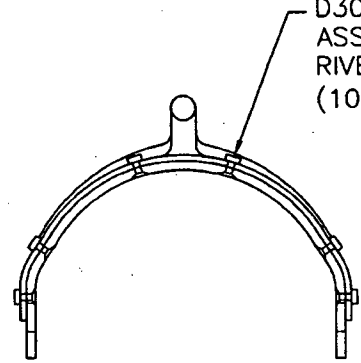
**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3046	REV. A
DATE 01.08.23		TITLE LUG BRACKET	SHEET 1 OF 2
A	01.08.23	NEW ISSUE	SCALE 1:2



TRANSFER DRILL  $\varnothing 0.156$  HOLES  
FROM D3046-3 TO D3046-1.  
C'SINK  $\varnothing 0.286 \times 100'$   
D3046-1 INSIDE BORE.  
ASSEMBLE USING MS20426AD5-7  
RIVETS.  
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

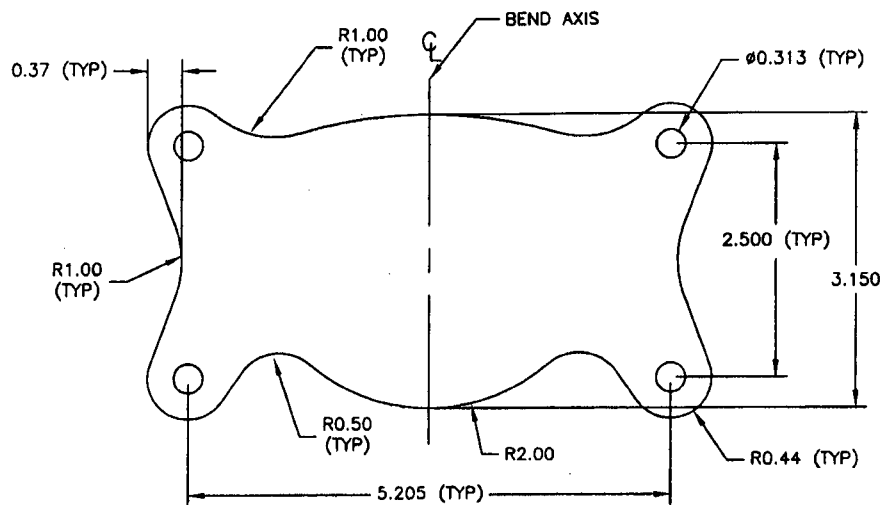
NOTES:  
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.  
REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

**UNDER REVIEW**  
06.09.06  
**RELEASED**  
01.08.23

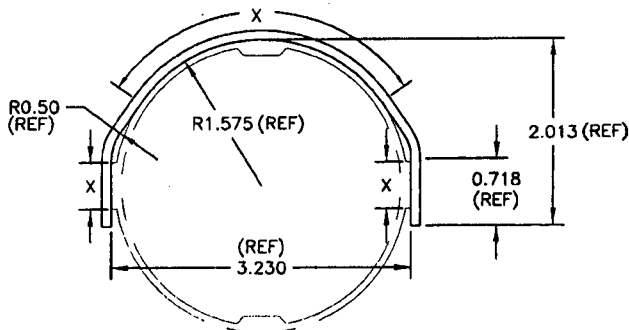
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
28435



DESIGN <i>[Signature]</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN  
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1  
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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NO. 28435  
RELEASED  
01.08.27

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